










Fire Red

Dart Aerospace Ltd.

Date: Monday, 27/04/2009 12:50:02 PM
 User: Julie Dawson

Process Sheet

| | |
|--|---|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : FRAME WELDMENT |
| Job Number : 47509 | |
| Estimate Number : 11202 | |
| P.O. Number : | Part Number : D3330041 |
| This Issue : 27/04/2009 S.O. No. : | Drawing Number : D3330 REV D |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : / / Type : LARGE FAB ASSY | Drawing Revision : D |
| Previous Run : 47508 | Material : |
| Written By : | Due Date : 25/05/2009 Qty: 2 Um: Each |
| Checked & Approved By : <u>Julie Dawson</u> | |
| Comment : Est. A05.01.13 New Issue KJ/JLM est B 07.05.14 revC dwg ec Est C 07.12.19 Rev Decn1085 EC | |
| Additional Product | |
| Job Number:  | |
| Seq. #: | Machine Or Operation: |
| Description : | |
| 1.0 | D33301 Panel |
|  |  |
| Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) Panel Pick: Qty Part Number Description Batch 1 D3330-1 Panel <u>B45326 = 2x</u> <u>SP 09.04.29</u> | |
| 2.0 | D33302 Panel |
|  |  |
| Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) Panel Pick: Qty Part Number Description Batch 1 D3330-2 Panel <u>B44239 = 1x</u> <u>B45331 = 1x</u> <u>SP 09.04.29</u> | |
| 3.0 | D33303 Panel |
|  |  |
| Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) Panel Pick: Qty Part Number Description Batch 1 D3330-3 Panel <u>B45278 = 2x</u> <u>SP 09.04.29</u> | |
| 4.0 | D33305 Panel |
|  |  |
| Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) Rail Pick: Qty Part Number Description Batch 1 D3330-5 Panel <u>B45077 = 2x</u> <u>SP 09.04.29</u> | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries

Date: Monday, 27/04/2009 12:50:02 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FRAME WELDMENT

Job Number: 47509

Part Number: D3330041

Job Number:



Seq. #:

Machine Or Operation:

Description :

1 D3330-5 Panel

5.0

D33307

Panel



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Panel

Pick:

Qty Part Number Description Batch

1 D3330-7 Panel *B45078 = 2x*

SP 09.04.29

6.0

D33309

Top Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Top Plate

Pick:

Qty Part Number Description Batch

1 D3330-9 Panel *B45079 = 2x*

SP 09.04.29

7.0

D333011

Long Pin Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Long Pin Bracket

Pick:

Qty Part Number Description Batch

1 D3330-11 Long Pin Bracket *B45327 = 2x*

SP 09.04.29

8.0

D333013

Short Pin Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Short Pin Bracket

Pick:

Qty Part Number Description Batch

1 D3330-13 Short Pin Bracket *B45328 = 2x*

SP 09.04.29

9.0

D333015

Handle



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Handle

Pick:

Qty Part Number Description Batch

1 D3330-15 Handle *B37080 = 2x*

SP 09.04.29

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC *Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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Date: Monday, 27/04/2009 12:50:02 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FRAME WELDMENT

Job Number: 47509

Part Number: D3330041

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

D333017

Handle Socket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Handle Socket

Pick:

Qty Part Number Description Batch
1 D3330-17 Handle Socket B44367=1x.
B44204 = 1x

SP 09.04.29

11.0

D333019

Handle Rim



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Handle Rim

Pick:

Qty Part Number Description Batch
1 D3330-19 Handle Rim B45330 = 2x

SP 09.04.29

12.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Assemble and Weld as per Dwg Dwg D3330 using D3330-041T1

Identify as D3330-041

SP 09.04.30 (2x)

13.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

BE 09-04-30 (2x)

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/04/30 (12)

15.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

START TIME: 9:55

OVEN TEMPERATURE: 320°

FINISH TIME: 10:25

UMP FL 09/05/01 (x2)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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Date: Monday, 27/04/2009 12:50:02 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FRAME WELDMENT

Job Number: 47509

Part Number: D3330041

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-05-01

x2

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Carl

SS 09/05/04 x2

18.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/04

Job Completion



MF 09-05-04

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

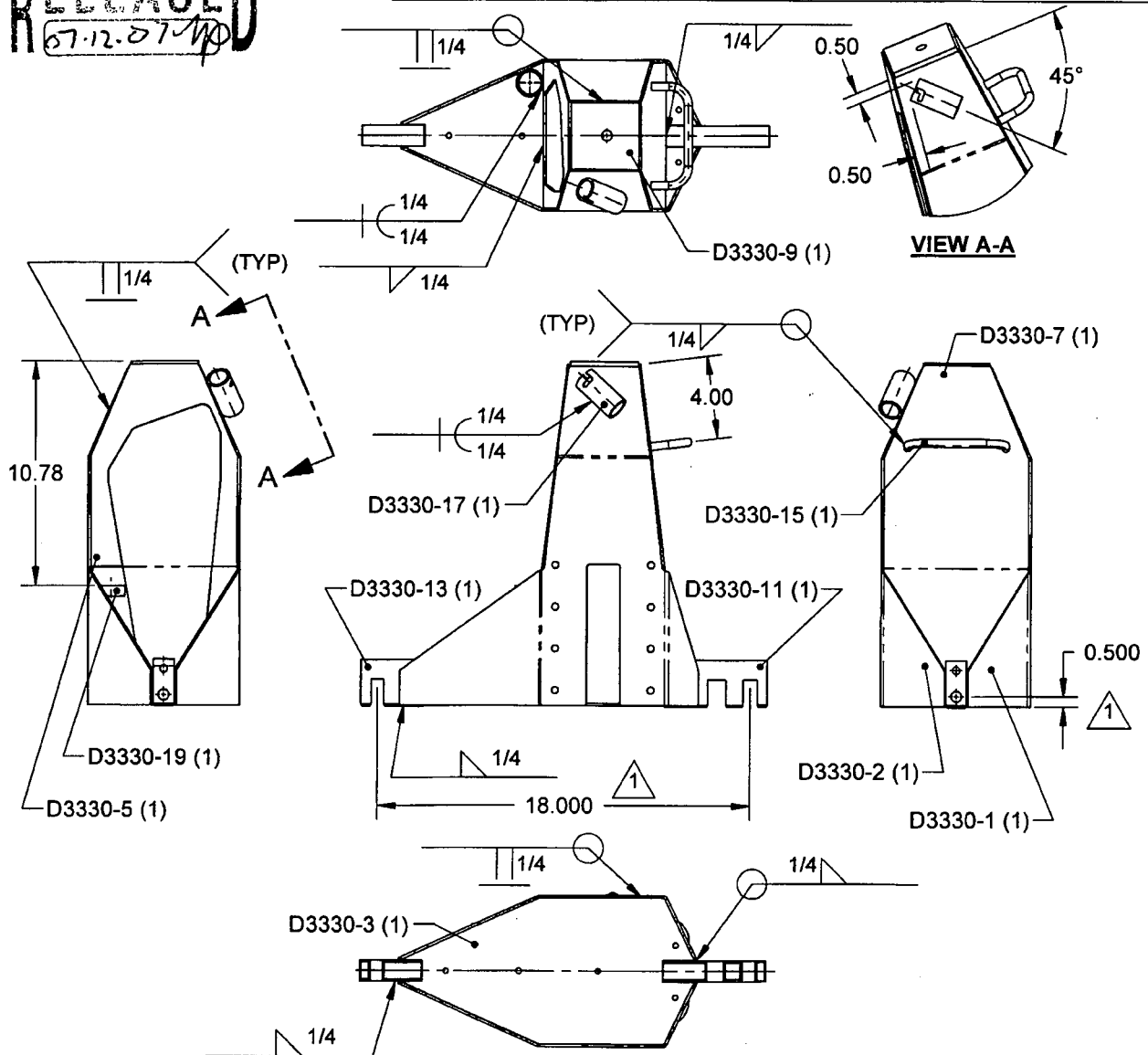
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

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| DATE 07.12.06 | | TITLE FRAME WELDMENT | SCALE 1:8 |
| REV | DATE | DESCRIPTION | |
| A | 04.12.16 | NEW ISSUE | |
| B | 05.02.26 | RE-DESIGN | |
| C | 07.03.20 | ADD 0.100 DIM; RAISED BEND OF -1/-2 BY 0.125 | |
| D | 07.12.06 | CHANGE DIMS ON D3330-9 | |

**D3330-041 FRAME WELDMENT****NOTES:**

- 1) POSITION PARTS AS PER JIG D3330-041T1
- 2) WELD PER QSI 004
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

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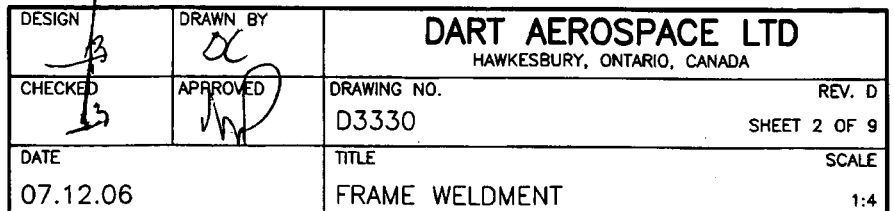
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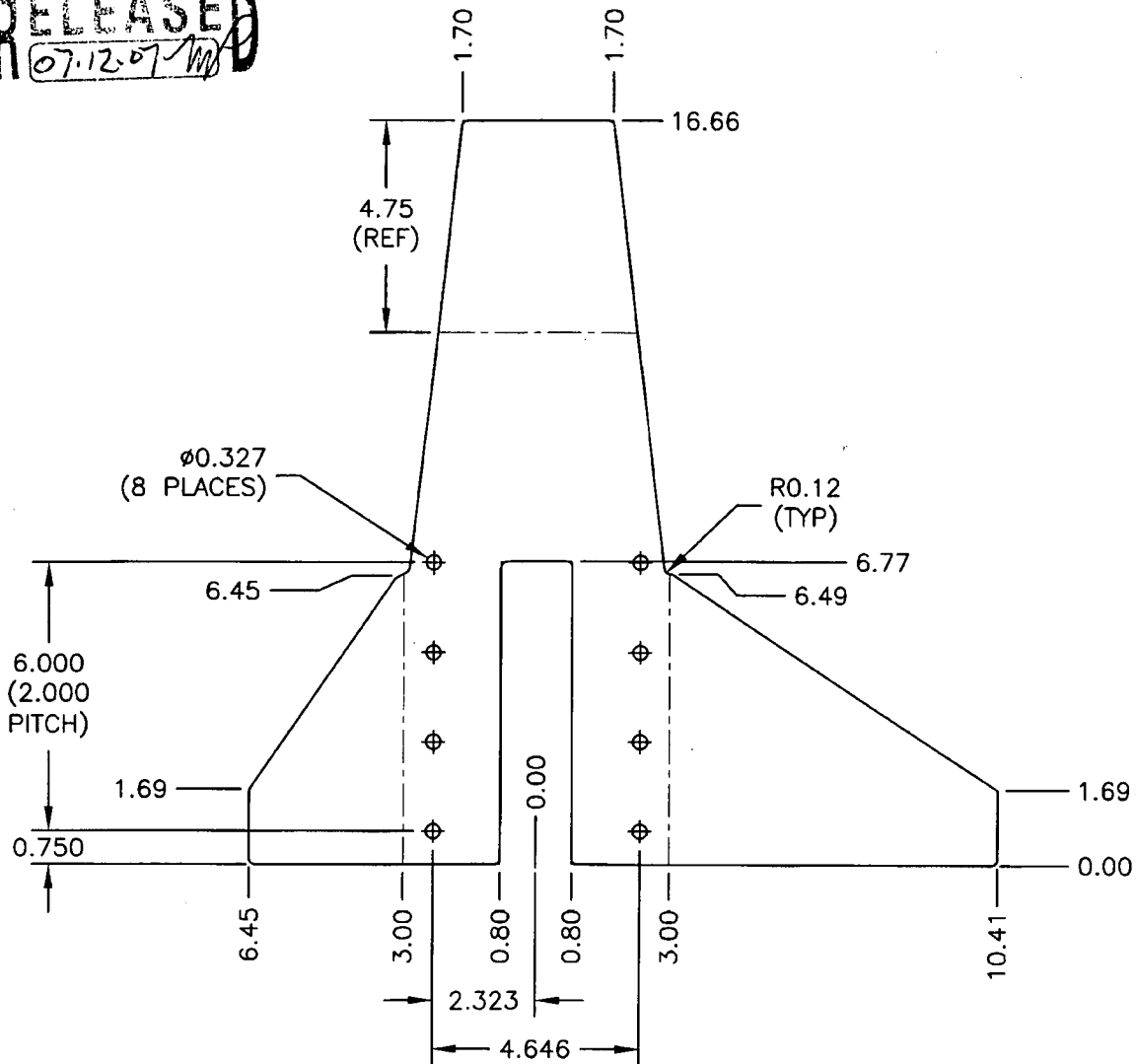
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- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE INCHES
4) BREAK ALL SHARP EDGES 0.005 TO 0.010

NO

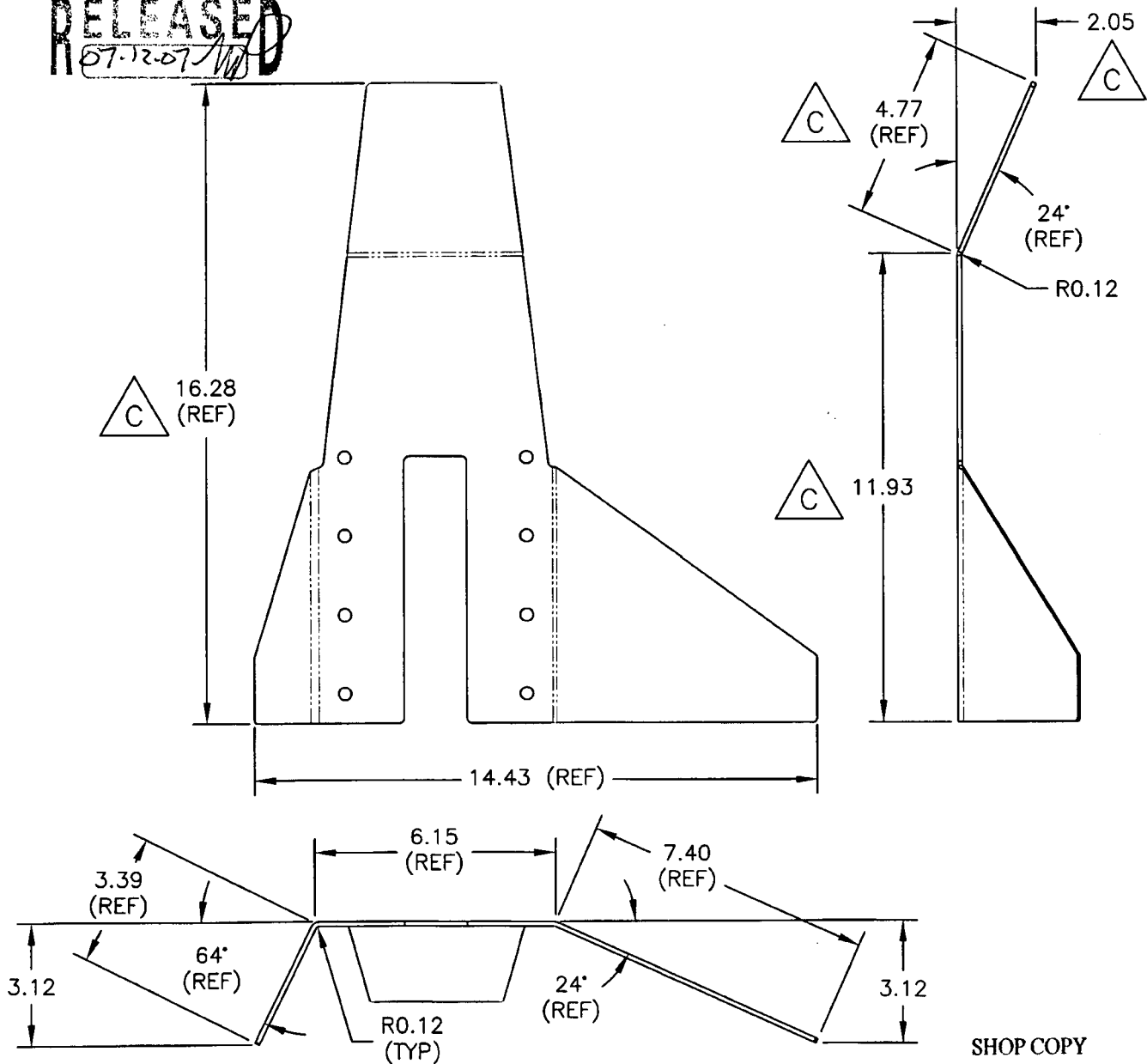
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| DATE 07.12.06 | | TITLE FRAME WELDMENT | SCALE 1:4 |

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D3330-1 BEND DETAIL (SHOWN)
BEND D3330-2 (OPPOSITE)

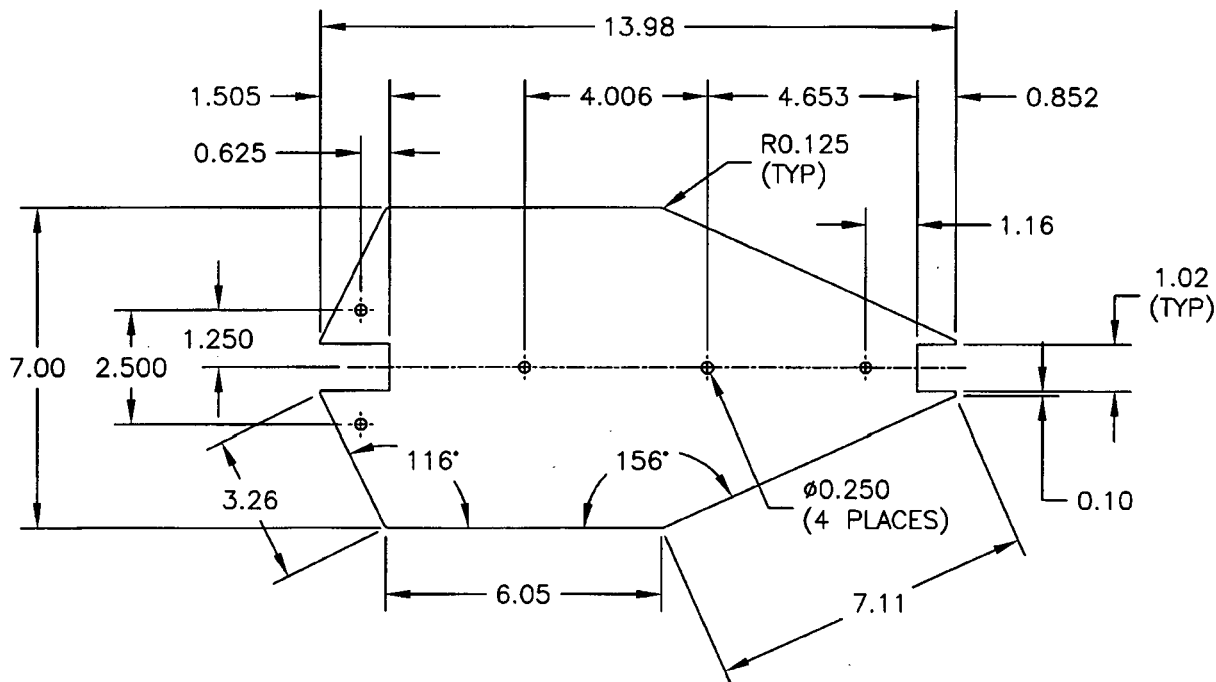
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| DATE 07.12.06 | | TITLE FRAME WELDMENT | SCALE 1:4 |

RELEASED
07.12.07**D3330-3 PLATE****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 INCH THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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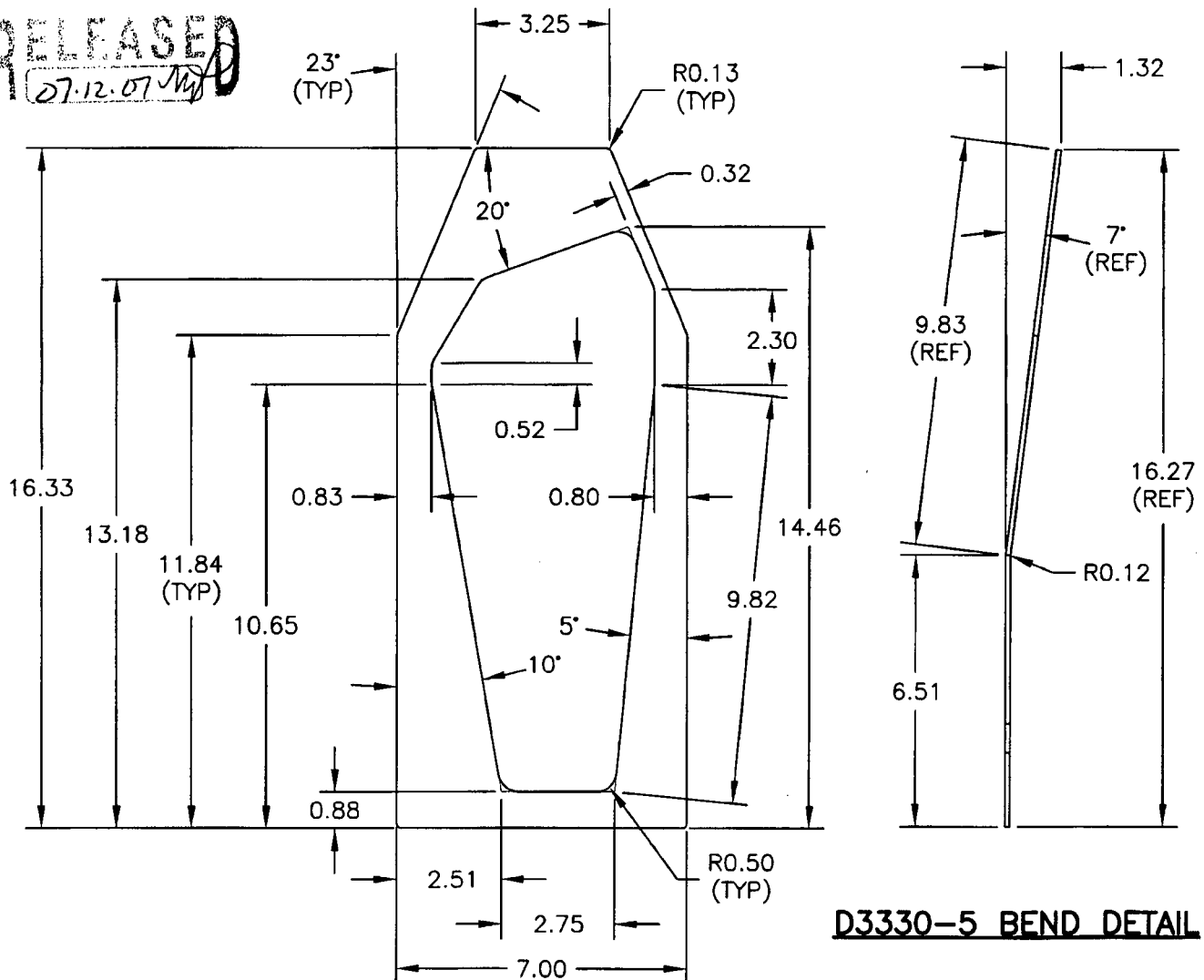
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| DATE 07.12.06 | | TITLE FRAME WELDMENT | SCALE 1:4 |

RELEASED
07.12.07**FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

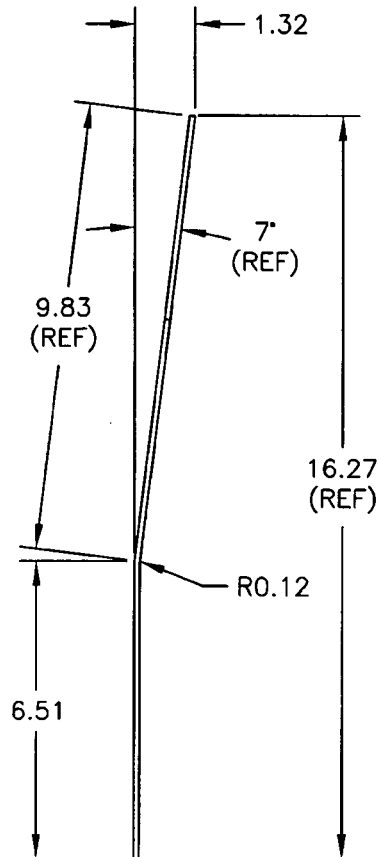
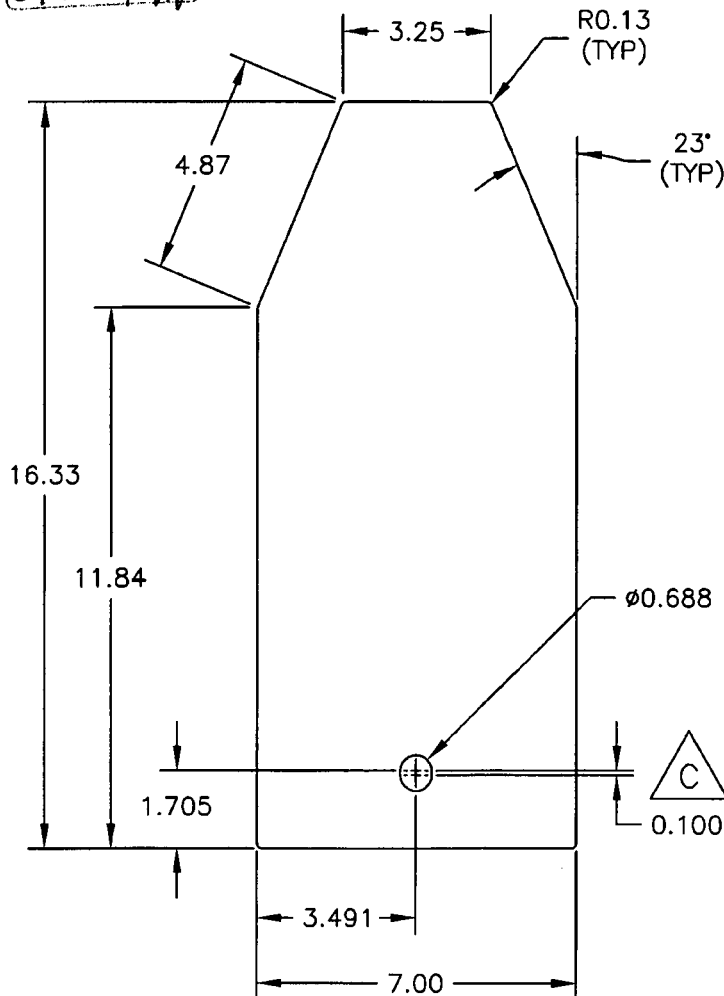
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| DATE 07.12.06 | | TITLE FRAME ASSEMBLY | SCALE 1:4 |

RELEASED
07.12.07 *MB***D3330-7 BEND DETAIL****FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40.21 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

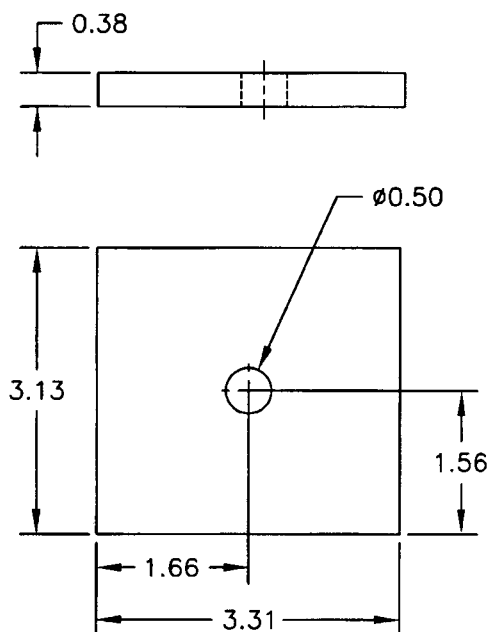
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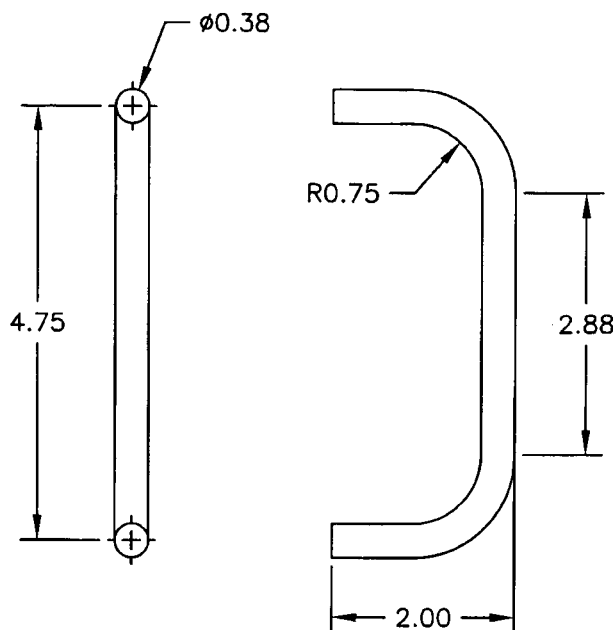


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| DATE 07.12.06 | | TITLE FRAME WELDMENT | SCALE 1:2 |

RELEASED
07.12.07 *[Signature]*



△ D3330-9 TOP PLATE



△ D3330-15 HANDLE

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008, 0.375 STEEL
(REF. DART SPEC. M1010-B0.375x3.500)
- 2) MATERIAL: AISI 1018-1025 ROUND BAR PER MIL-S-7097
(REF. DART SPEC. M1018-R0.375)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

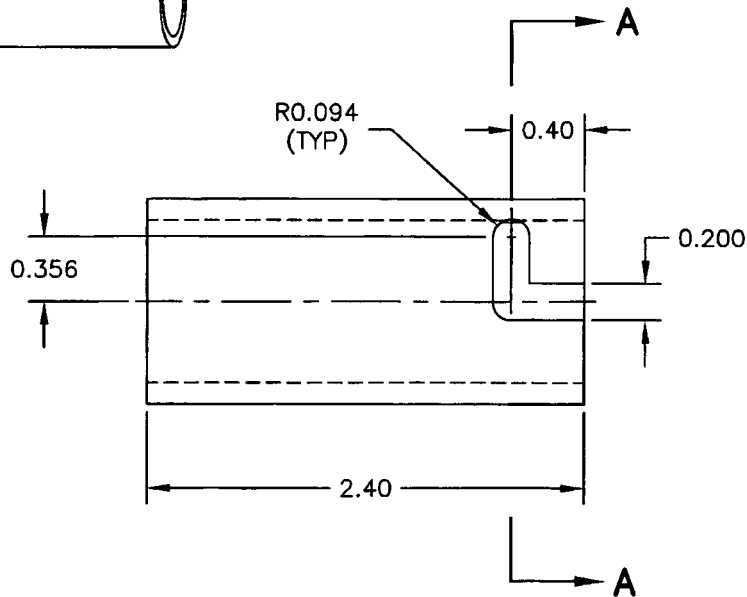
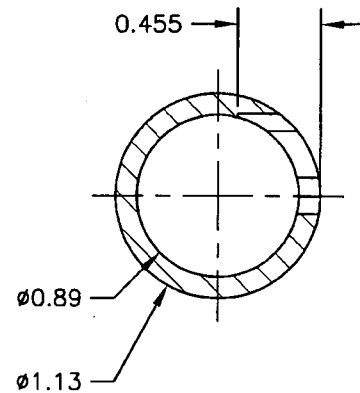
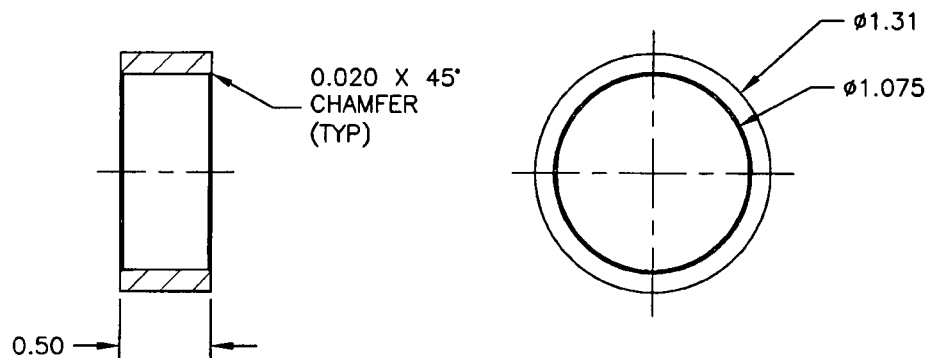
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| DATE 07.12.06 | | TITLE FRAME WELDMENT | SCALE 1:1 |

**RELEASED**
07.12.07 *[Signature]***SECTION A-A****D3330-17 HANDLE SOCKET****D3330-19 HANDLE RIM****NOTES:**

- 1) MATERIAL: 1010-1025 ROUND BAR STEEL PER MILL-S-7097 (REF. DART SPEC. M1025TR)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

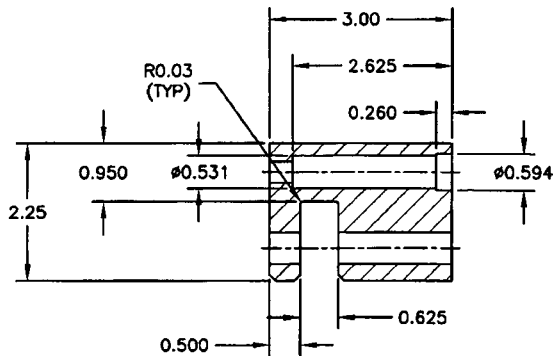
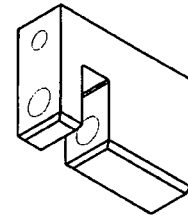
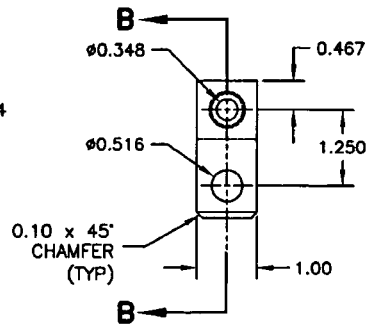
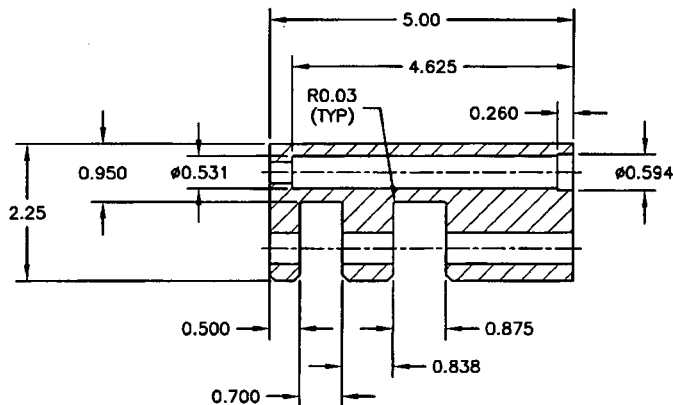
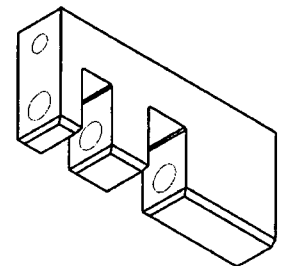
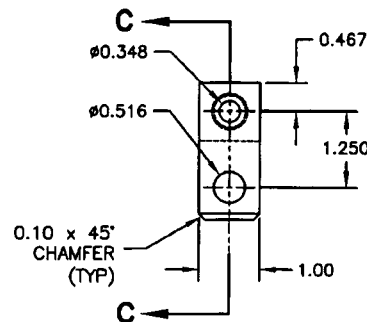
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| DATE 07.12.06 | | TITLE FRAME WELDMENT | SCALE 1:3 |

RELEASED
07.12.07**SECTION B-B****D3330-13 SHORT PIN BRACKET****SECTION C-C****D3330-11 LONG PIN BRACKET****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570, 1.000 THICK STEEL (REF. DART SPEC. M1010-B1.000x02.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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